

Work Order ID 52616

October 5, 2009 8:06:59 AM

Today



Page 1

Item ID: D3144-107

Accept



Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 10/05/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/06/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3144	Rev C								
100		0.00							
	PURCHASING								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3144								
	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

IB 9-10-5

(14)

IB 9-10-5

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

22 Soricolor



QC

Memo

0.00



Quality Control

130

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Debur if necessary

u/las

144

144

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

mp

09/11/05

x14

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Setup Start



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Item Name: Doubler

Start Date: 10/05/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/06/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M 10/09/09

Memo

0.00

START TIME: *1400*
OVEN TEMPERATURE: *3200*
FINISH TIME: *1130*

BL 09-10-5

(14)

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

20 501/0105

Memo

0.00

(618) f

170



Packaging

Packaging

Identify as per dwg & Stock Location: *CA*

0.00

Memo

0.00

Pc 9/1-15 10/16/05
(18)
u 09-10-05

Work Order ID 52616

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Item ID: D3144-107

Accept



Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 10/05/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/06/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/05

Picklist Print

October 5, 2009 8:06:58 AM

Page 1

Work Order ID: 52616

Parent Item: D3144-107RevC

Parent Item Name: Doubler

Comments:

Start Date: 10/05/09

Required Date: 10/06/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	80.4179	3.0737	2.00		



2024-T3 .032 sheet

IB 9-10-5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

80.41793158

102942

1.5

105555

4.0684

106272

5.3

108595

1.2

109240

7.02

110778

23.9106316

111699

34.4189

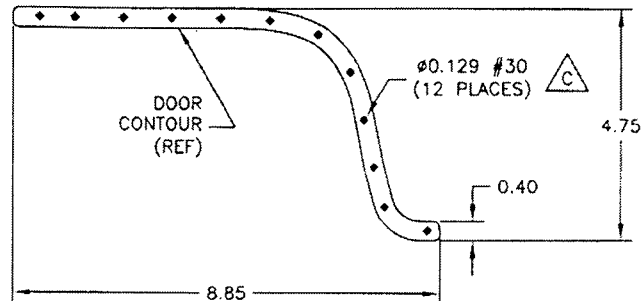
18147

3

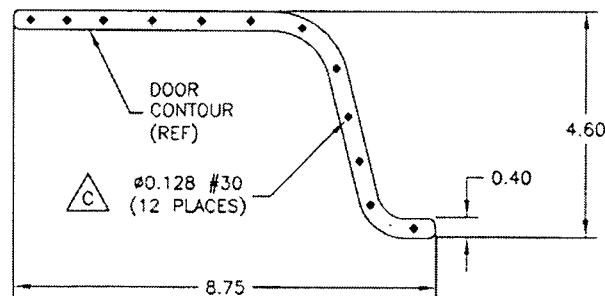
110778

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3144	REV. C SHEET 7 OF 9
DATE 05.10.19		TITLE DOUBLER	SCALE NTS



D3144-107 DOUBLER (FOR D412-694-03)



D3144-121 DOUBLER (FOR D412-694-04)

RELEASED

05.11.14

D3144-107/-121 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C7.DWG"

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